

Work Order ID **77523*****77523***

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December-12-11 3:00:13 PM

Item ID: D2581

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Bracket

Start Date: 12/12/2011 Start Qty: 20.00

20

Cust Item ID:

Required Date: 16/12/2011 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: M.C.JDate: 11/12/12 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2581

Rev A1

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2581

Dwg Rev: A1Prog Rev: A1

2-Deburr if necessary

B117-1459

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B117-14

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Sanchezx29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77523

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77523

Page 2

Item ID: D2581 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Bracket
 Start Date: 12/12/2011 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 16/12/2011 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00		SP 11/12/19		(29)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5 11/12/19		(79)			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>W/A</u> Memo *****STOCK IN BASKET CELL*****	0.00 0.00		CP 11-12-19		X29			

W/O:		WORK ORDER CHANGES					
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Page 3

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Accept

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Revision ID:

Item Name: Mounting Bracket

Stop ***NS2***

Start Date: 12/12/2011 Start Qty: 20.00

20

Cust Item ID:

Required Date: 16/12/2011 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

11/12/2011
M 11-1220
(29)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 1

Work Order ID: 77523

77523

Parent Item: D2581

D2581

Parent Item Name: Mounting Bracket

Start Date: 12/12/2011

Required Date: 16/12/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP D01.07.17Added info to step 2SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

62.5000

0.0187

0.393684

16

M304S11GA

**

B112-14

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

62.5

119006

32.5

119048

30

119048

29

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

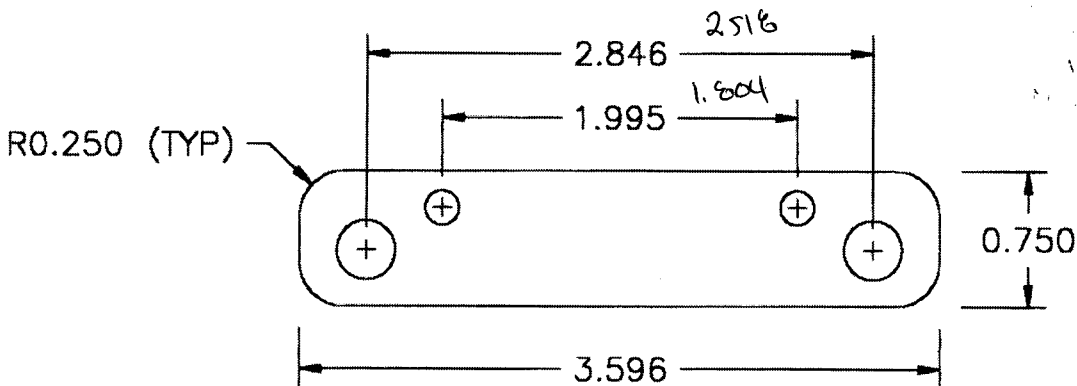
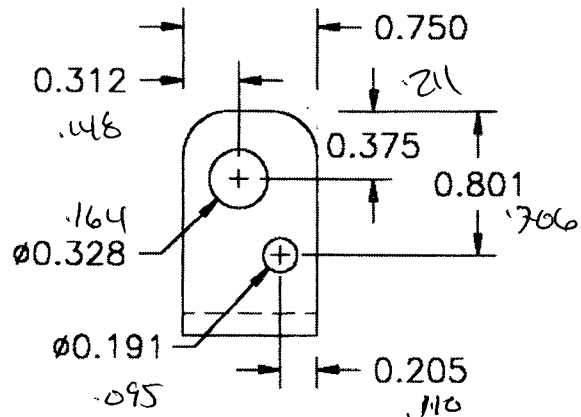
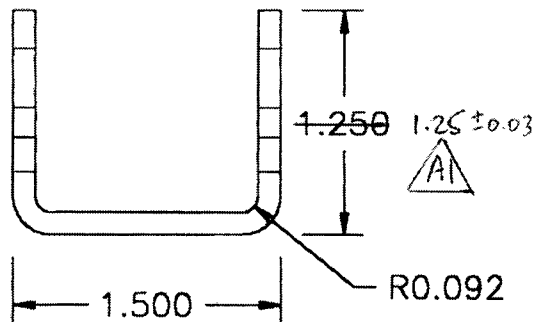
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DESIGN		DRAWN BY		DART AEROSPACE LTD	
MIKE M		MIKE M		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. A
BW		M. M.		D2581	SHEET 1 OF 1
DATE		TITLE		SCALE	
96.06.27		MOUNTING BRACKET		1:1	
A1	CP	04.05.14		CHANGE TOLERANCE ON 1.25 DIMENSION	

RELEASED
96/07/23 BW



SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
TO AMENDMENT
NOTICE
ORDER

77523 M.C.J
11/12/12

MATERIAL: 304/316 SS 0.125 THICK

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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